

Date: Monday, 07/04/2008 2:30:13 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | | |
|-----------------------|---|------------|--------------|-----------------------|---------------|----------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : FUEL PURGE CANISTER | | | |
| Job Number | : 38446B | | | | | | |
| Estimate Number | : 10442 | | | | | | |
| P.O. Number | : | | | Part Number | : D32623 | | |
| This Issue | : 07/04/2008 | S.O. No. : | | Drawing Number | : D3262 REV C | | |
| Prsht Rev. | : NC | | | Project Number | : N/A | | |
| First Issue | : / / | | Type | : MACHINED PARTS | | | |
| Previous Run | : 37369B | | | Drawing Revision | : C | | |
| Written By | : | | | Material | : | | |
| Checked & Approved By | : <u>JL</u> 08.4.06 | | | Due Date | : 30/04/2008 | | |
| Comment | : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K | | | Qty: | 8 | Um: Each | |
| J/JLM | | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 1.0 | M6061T6B0500X06000 | 6061-T6 Bar .50" x 6.0" |
| | | |
| | | Comment: Qty.: 0.9668 f(s)/Unit Total : 7.7347 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: <u>131027244</u> |
| 2.0 | BAND SAW | BAND SAW |
| | | |
| | | Comment: BAND SAW Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| | | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per dwg D3262 |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 38446B

Part Number: D32623

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

AS 08/05/17 (X)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST174

AS 08/05/21 (X)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2008

Job Completion



MF 08-05-21

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 384446B |
| Description: Cap | Part Number: | D3262-3 |
| Inspection Dwg: D3262 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

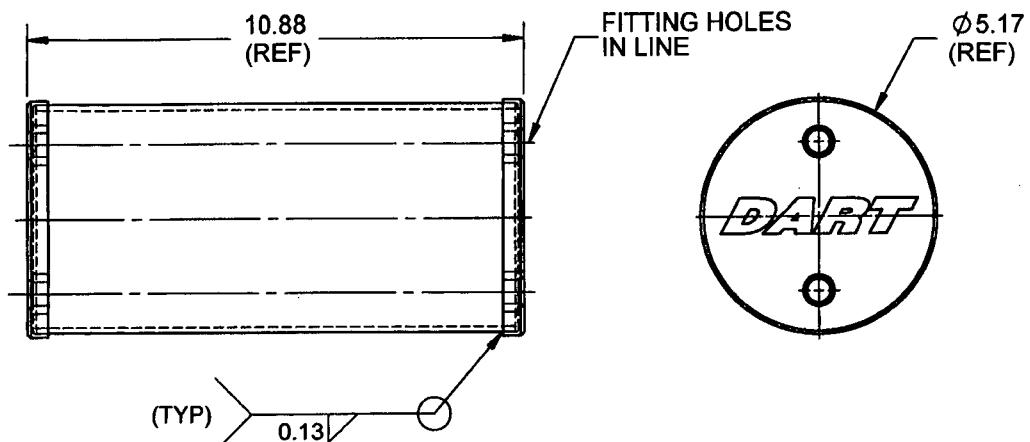
| | | | | | |
|--------------|----------|-------------|-----------|---------------------|-----|
| Measured by: | J.L | Audited by: | <i>SS</i> | Prototype Approval: | N/A |
| Date: | 08/05/17 | Date: | 08/05/17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A | 04.09.03 | New Issue P/O D3262-041 | KJ/JLM | |
| B | 05.04.28 | Dimensions and tolerances revised | KJ/JLM | |
| C | 06.09.27 | Dimensions revised per rev. C | KJ/JLM | |
| D | 07.09.06 | 0.080 was 0.090 | KJ/JLM | ZB |

DART

| | | | |
|----------------------|-------------------------------------|--|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>JB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>HF</i> | DRAWING NO. D3262 | REV. C SHEET 1 OF 2 |
| DATE 06.08.31 | TITLE FUEL PURGE CANISTER | | SCALE 1:4 |
| REV | DATE | DESCRIPTION | |
| A | 04.05.06 | FIRST ISSUE | |
| B | 05.02.14 | ADD PRESSURE TESTING OPTION | |
| C | 06.08.31 | $\phi 5.165$ WAS $\phi 5.190$ | |

RELEASED

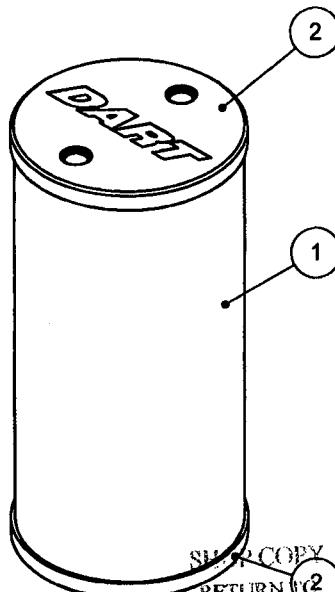
06.09.19 *HF*

D3262-041 CANISTER ASSEMBLY

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------------|
| | X | D3262-041 | CANISTER ASSEMBLY |
| 1 | 1 | D3262-1 | TUBE |
| 2 | 2 | D3262-3 | CAP |

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO **A**
CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



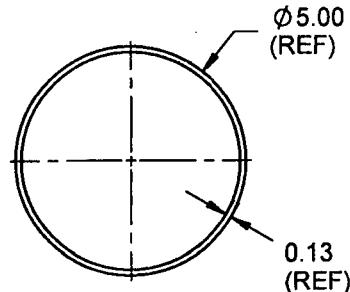
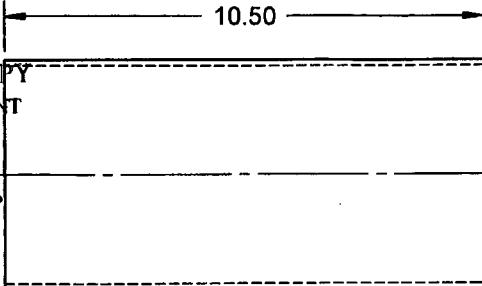
DART

| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>BS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>MM</i> | DRAWING NO. D3262 | REV. C SHEET 2 OF 2 |
| DATE 06.08.31 | | TITLE FUEL PURGE CANISTER | SCALE 1:4 |

SHOP COPY

RETURN TO
ENGINEERING

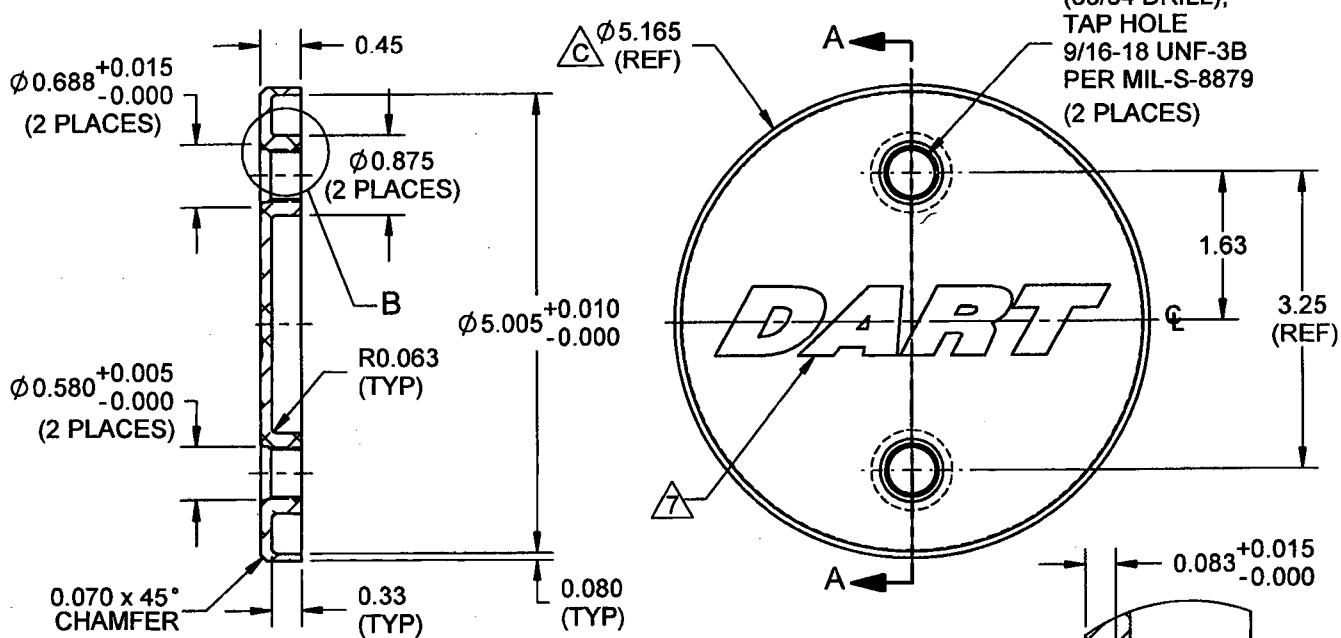
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38441ab



RELEASED
BS 09-14

D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



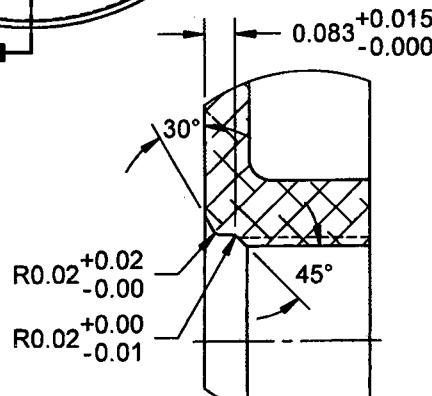
SECTION A-A
SCALE 1:2

D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



DETAIL B
SCALE 2:1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D326 2-3 PAR #: N/A Fault Category: Prod Machined Parts NCR: Yes No DQA: Date: 08/05/20 QA: N/C Closed: Date: 08/05/20

| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/05/16 | 3 | 1 piece scrap the charter 0.688 too big of .050. PC. shank for tool wasn't given enough of an offset by the operator on his set-up | 08/05/16 | - Scrap and Destroy and replace QTY <input checked="" type="checkbox"/> B# 107244 | 08/05/16 | 08/05/20 | 08/05/20 | 08/05/20 |
| | | | | - Modify program to fix the tool depth. <input checked="" type="checkbox"/> attached | 08/05/20 | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

N426 (MACHINE CHAMFER)
N427 (T17-1/2" 45DEG CHAMFER TOOL)
N428 T17 M6
N429 G0 G90 G54 X5.9185 Y2.8875 S4000 M3
N430 G43 Z0.9 H17 M8
N431 G0 Z0.099
N432 G1 ~~Z-0.101~~ F10.0 *x.050"*
N433 G3 X5.731 Y2.7 I0 J-0.1875
N434 G2 I-2.731 J0 F20.0
N435 G3 X5.9185 Y2.5125 I0.1875 J0 F10.0
N436 G0 Z0.9
N437 Y2.8875
N438 Z0.099
N439 G1 Z-0.101
N440 G3 X5.731 Y2.7 I0 J-0.1875
N441 G2 I-2.731 J0 F20.0
N442 G3 X5.9185 Y2.5125 I0.1875 J0 F10.0
N443 G0 Z0.9
N444 G0 G49 G90 Z0 M9
N445 G28 G91 Y0 Z0
N446 M30
8

New

N410 G0 Z1.5
(ROUGH CONTOUR)
(T3-1/2" ISCAR ROUGHER .250" DEEP)

OID

N411 T3 M06

N412 S10000 M03

N413 M08

N414 G0 G54 X6.28 Y3.075

N415 G43 H03 Z1.

N416 Z.07

N417 G1 Z-.28 F15.

N418 G3 X5.905 Y2.7 I0. J-.375

N419 G2 X5.905 Y2.7 I-2.905 J0. F65.

N420 G3 X6.28 Y2.325 I.375 J0. F15.

N421 G0 Z1.

(MACHINE CHAMFER)

(T17-1/2" 45DEG CHAMFER TOOL)

N422 T17 M06

N423 S4000 M03

N424 M08

N425 G0 G54 X5.9185 Y2.8875

N426 G43 H17 Z.9

N427 Z.049

N428 G1 Z-.151 F10.

N429 G3 X5.731 Y2.7 I0. J-.1875

N430 G2 X5.731 Y2.7 I-2.731 J0. F20.

N431 G3 X5.9185 Y2.5125 I.1875 J0. F10.

N432 G0 Z.9

N433 Y2.8875

N434 Z.049

N435 G1 Z-.151

N436 G3 X5.731 Y2.7 I0. J-.1875

N437 G2 X5.731 Y2.7 I-2.731 J0. F20.

N438 G3 X5.9185 Y2.5125 I.1875 J0. F10.

N439 G0 Z.9

G00 G49 G90 Z0.0 M9

G28 G91 Y0.0 Z0.0

M30

%